

to make it as light as possible to handle. Lugs project wherever necessary to give ample bearings to the lining bushings and, in turn, to the loose guiding bushings.

Fig. 23 shows two closed jigs made up of two main parts which are planed and assembled by screws and dowels as indicated, the reason for making the jigs in this way being the case of planing the bottom section. The work drilled in these jigs, some special slides, is located by the dovetail and held up against one dovetail side by set-screws *A*, as shown in the illustration. In the jig

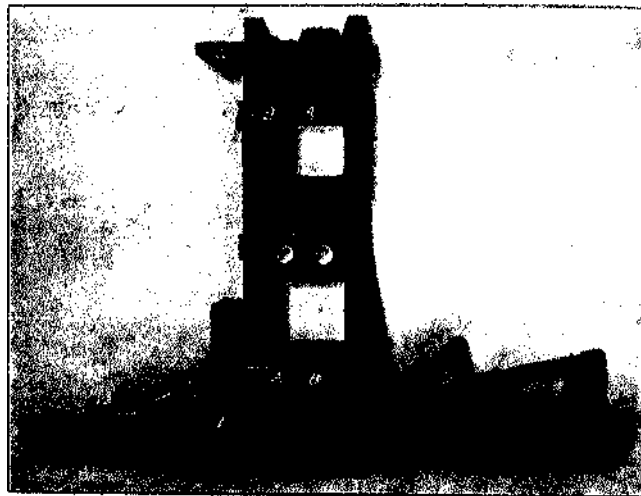


Fig. 34. Jig for Drilling  
Holes for other parts

to the left, the work is located endwise against it dowel pin and is held up against this stop by a set-screw through the block shown to the left. This block must **be** taken out when the slide *Is* inserted, this being the reason why a lug cast directly in place, through

which the set-screw could pass, is not used. The top plate *D* is held down on the main body by six flange-head screws *E*, and two dowel pins *F* prevent it from shifting. No clamping arrangements, except the set-screws *A*, are necessary. The holes being drilled from the top, the main body of the jig takes the thrust. These jigs are also used in multiple-spindle drills,

One objectionable feature of the jig to the right in Fig. 23 is that set-screws *A* are difficult of access. There are, therefore,